IN THE CLAIMS

Please amend the claims as follows:

Claim 1 (currently amended): A method of manufacturing an aluminum extruded raw pipe, ~~including the step of~~ comprising:

extruding [[an]] a solid aluminum billet having a solidified shell layer formed at an external peripheral surface thereof, the solidified shell layer having the maximum thickness of 13 mm or less.

Claim 2 (original): The method of manufacturing an aluminum extruded raw pipe as recited in claim 1, wherein the maximum thickness of the solidified shell layer is 11 mm or less.

Claim 3 (currently amended): The method of manufacturing an aluminum extruded raw pipe as recited in claim 1 ~~or 2~~, wherein the solid aluminum billet is made of A3003 aluminum alloy.

Claim 4 (currently amended): The [[A]] method of manufacturing ~~an aluminum billet in accordance with~~ an aluminum extruded raw pipe as recited in claim 1, wherein the solid aluminum billet is obtained by a float casting method[[,]] including ~~the step of:~~ casting an aluminum billet at a casting rate of 95 mm/minute or less.

Claim 5 (currently amended): The method of manufacturing ~~an aluminum billet as recited in claim 4~~ an aluminum extruded raw pipe as recited in claim 1, wherein the solid aluminum billet is obtained by a float casting method including ~~the casting is performed at a~~ casting an aluminum billet at a casting rate of 85 to 90 mm/minute.

Claim 6 (currently amended): The [[A]] method of manufacturing ~~an aluminum billet in accordance with~~ an aluminum extruded raw pipe as recited in claim 1, wherein the solid aluminum billet is obtained by a float casting method~~, including the step of:~~ including casting

an aluminum billet while keeping a distance from a lowermost portion of a mold to an upper surface position of a molten aluminum to be 40 mm or less.

Claim 7 (currently amended): The method of manufacturing ~~the aluminum billet as recited in claim 6~~ an aluminum extruded raw pipe as recited in claim 1, wherein the solid aluminum billet is obtained by a float casting method including [[the]] casting an aluminum billet ~~is performed~~ while keeping [[the]] a distance from [[the]] a lowermost portion of [[the]] a mold to [[the]] a upper surface position of [[the]] a molten aluminum to be 30 to 35 mm.

Claim 8 (currently amended): The [[A]] method of manufacturing ~~an aluminum billet in accordance with~~ an aluminum extruded raw pipe as recited in claim 2, wherein the solid aluminum billet is obtained by a float casting method~~, including the step of:~~ including casting an aluminum billet at a casting rate of 95 mm/minute or less while keeping a distance from a lowermost portion of a mold to an upper surface position of a molten aluminum to be 40 mm or less.

Claims 9-11 (canceled)

Claim 12 (currently amended): A method of manufacturing an aluminum extruded raw pipe as recited in ~~any one of claims 1, 2, 3 and 11~~ claim 1, wherein the aluminum extruded raw pipe is an aluminum extruded raw pipe to be used as a photosensitive drum.

Claim 13 (currently amended): An aluminum extruded raw pipe manufactured by the method as recited in ~~any one of claims 1, 2, 3 and 11~~ claim 1.

Claim 14 (currently amended): An aluminum extruded raw pipe to be used as a photosensitive drum, wherein the aluminum extruded raw pipe is manufactured by the method as recited in ~~any one of claims 1, 2, 3 and 11~~ claim 1.

Claim 15 (currently amended): A method of manufacturing an aluminum pipe to be used as a photosensitive drum, ~~including the step of~~ comprising:

subjecting the aluminum extruded raw pipe manufactured by the method as recited in ~~any one of claims 1, 2, 3 and 11~~ claim 1 to a drawing process.

Claim 16 (currently amended): A method of manufacturing an aluminum pipe to be used as a photosensitive drum,

subjecting the aluminum extruded raw pipe manufactured by the manufacturing method as recited in ~~any one of claims 1, 2, 3 and 11~~ claim 1 to an ironing process.

Claim 17 (currently amended): An aluminum pipe to be used as a photosensitive drum, wherein the aluminum pipe is manufactured by the method as recited in claim 15 ~~or 16~~.

Claim 18 (new): An aluminum pipe to be used as a photosensitive drum, wherein the aluminum pipe is manufactured by the method as recited in claim 16.

Claim 19 (new): The method of manufacturing an aluminum extruded raw pipe as recited in claim 1, wherein the solid aluminum billet comprises A3003 aluminum alloy.

Claim 20 (new): A method of manufacturing an aluminum pipe to be used as a photosensitive drum, comprising:

extruding a solid aluminum billet having a solidified shell layer formed at an external peripheral surface thereof, thereby forming a solid aluminum raw pipe, the solidified shell layer having the maximum thickness of 13 mm or less; and

subjecting the solid aluminum raw pipe to a drawing process.

Claim 21 (new): The method of manufacturing an aluminum pipe as recited in claim 20, further comprising casting an aluminum billet at a casting rate of 95 mm/minute or less by a float casting method, thereby obtaining the solid aluminum billet.

Claim 22 (new): A method of manufacturing an aluminum pipe to be used as a photosensitive drum, comprising:

extruding a solid aluminum billet having a solidified shell layer formed at an external peripheral surface thereof, thereby forming a solid aluminum raw pipe, the solidified shell layer having the maximum thickness of 13 mm or less; and

subjecting the solid aluminum extruded raw pipe to an ironing process.

Claim 23 (new): The method of manufacturing an aluminum pipe as recited in claim 22, further comprising casting an aluminum billet at a casting rate of 95 mm/minute or less by a float casting method, thereby obtaining the solid aluminum billet.